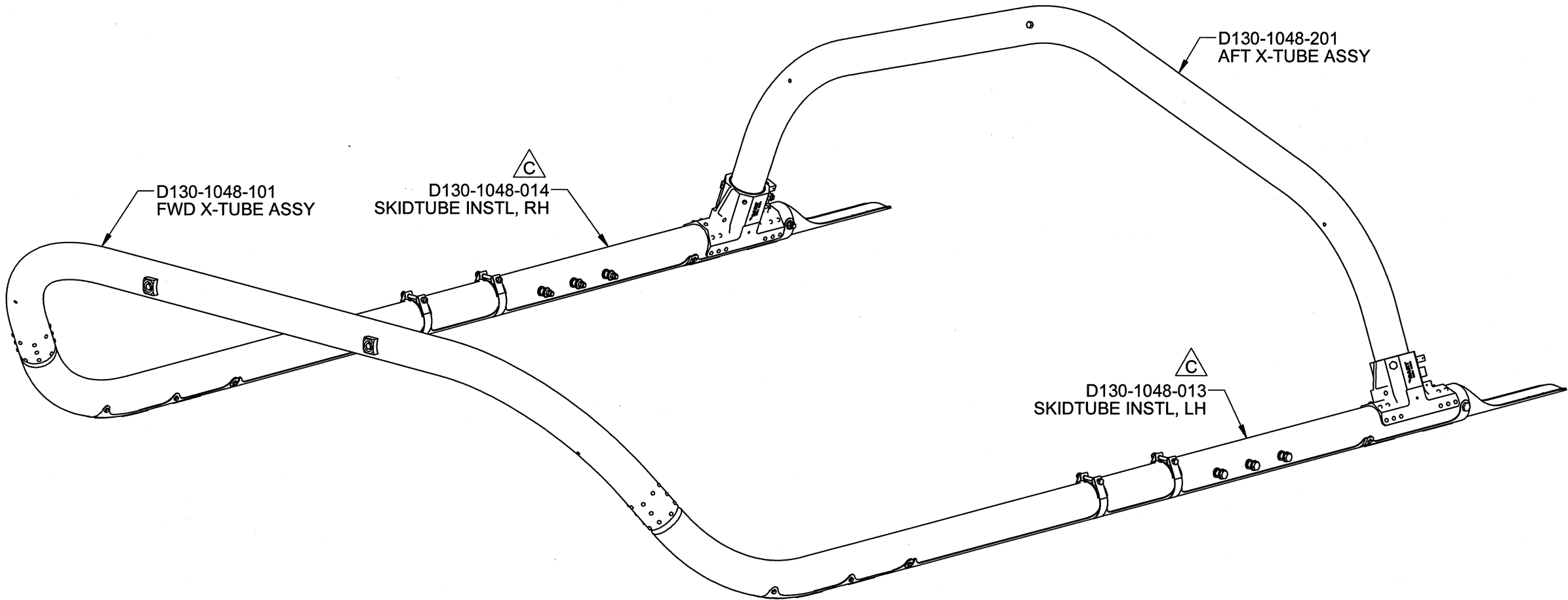


| QTY<br>-711 | P/N           | DESCRIPTION                  |
|-------------|---------------|------------------------------|
| X           | D130-1048-711 | HEAVY DUTY LANDING GEAR ASSY |
| 1           | D130-1048-013 | SKIDTUBE INSTL, LH (EC130)   |
| 1           | D130-1048-014 | SKIDTUBE INSTL, RH (EC130)   |
| 1           | D130-1048-101 | FWD X-TUBE ASSY (EC130)      |
| 1           | D130-1048-201 | AFT X-TUBE ASSY (EC130)      |



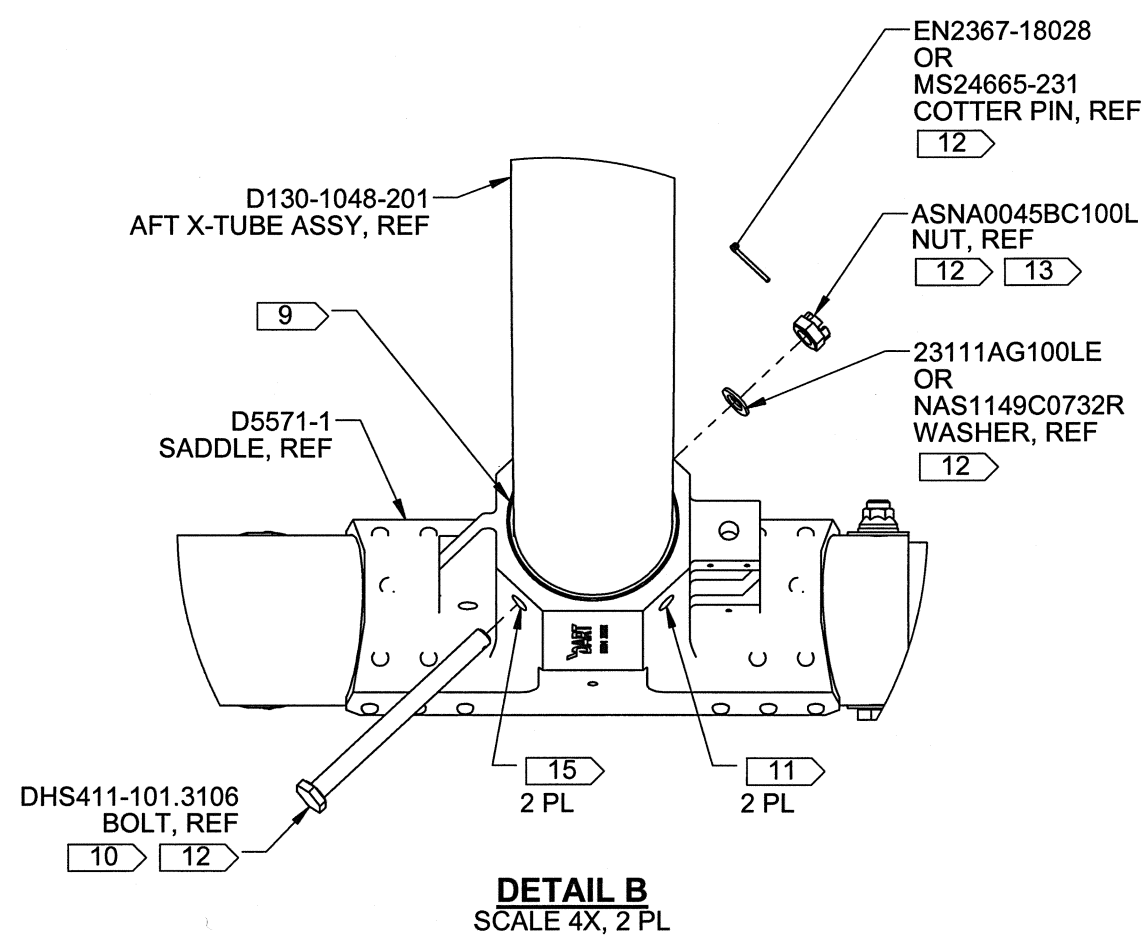
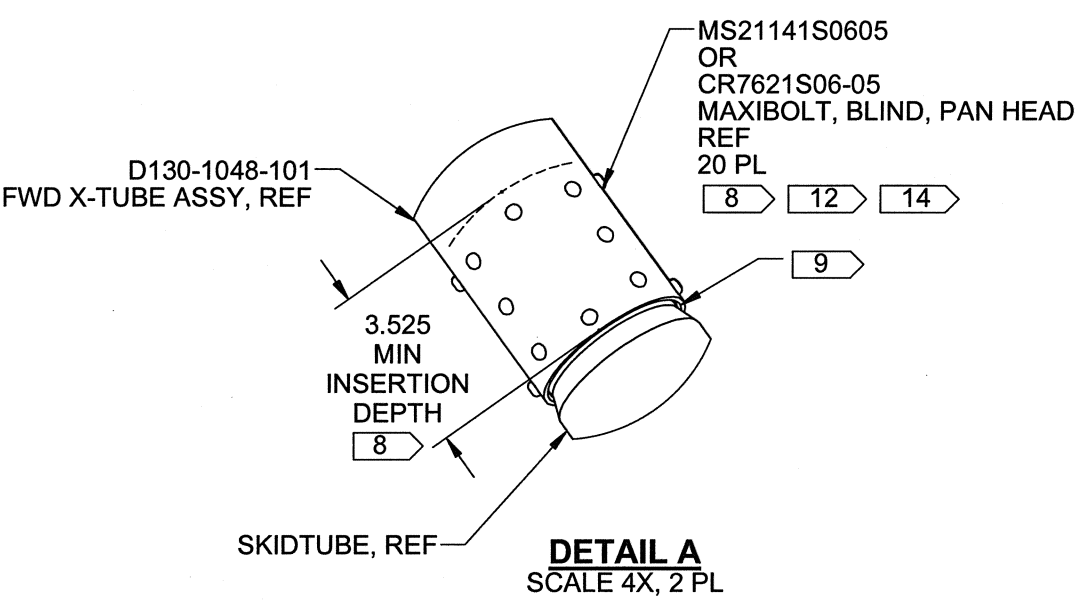
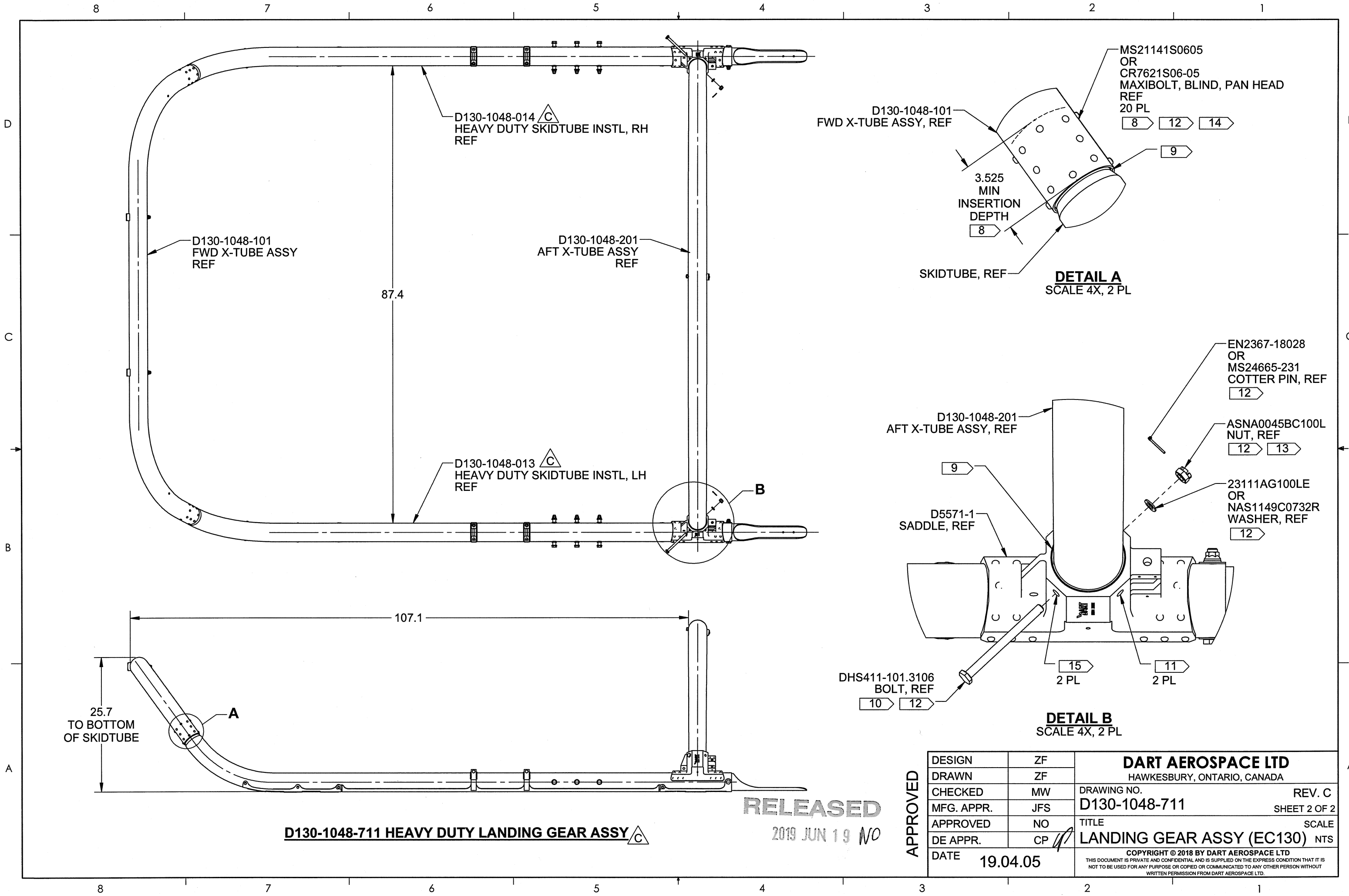
**D130-1048-711 HEAVY DUTY LANDING GEAR ASSY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 114.9 LBs
  - 8) ENSURE 3.525 MINIMUM INSERTION DEPTH OF SKIDTUBE INTO CROSSTUBE. TRANSFER DRILL  $\phi 0.129$  HOLES FROM CROSSTUBE TO SKIDTUBE, OPEN HOLES THRU CROSSTUBE AND SKIDTUBE TO  $\phi 0.199 - \phi 0.202$ . INSTALL MS21141S0605 MAXIBOLT, BLIND, PAN HEAD.
  - 9) FILLET SEAL WITH SIKAFLEX -241/-291 OR PROSEAL PS890/PR1422 OR MIL-S-8802 CLASS B SEALANT
  - 10) CLEAN THE MATING SURFACES OF THE AFT CROSSTUBE, SADDLE, AND BOLT TO ENSURE GOOD ELECTRICAL BONDING. INSTALL BOLT WET WITH ELECTRICALLY CONDUCTIVE COMPOUND, BURNDY PENETROX A-13.
  - 11) PLUG SEAL UNUSED HOLES IN SADDLE WITH SIKAFLEX -241/-291 OR PROSEAL PS890/PR1422 OR MIL-S-8802 CLASS B SEALANT
  - 12) HARDWARE FOR ASSEMBLING SKIDTUBES TO CROSSTUBES SUPPLIED AS PART OF D130-1048-013/-014 SKIDTUBES.
  - 13) TORQUE NUT TO 97-106 IN-LBS.
  - 14) IT IS ACCEPTABLE TO USE CR7651S06-05 OVERSIZE MAXIBOLTS FOR REPAIR OF OVERSIZED HOLES. IN THIS CASE, OPEN HOLES THRU CROSSTUBE AND SKIDTUBE TO  $\phi 0.215 - \phi 0.218$
  - 15) ENSURE THAT THE AFT CROSSTUBE IS POSITIONED SUCH THAT THE STOP BLOCK IS ON THE AIRCRAFT'S RIGHT HAND SIDE. TRANSFER DRILL HOLES FROM SADDLES TO THE AFT CROSSTUBE. QTY (2) D5715-1 DRILL BUSHINGS ARE PROVIDED WITH THE AFT CROSSTUBE TO ASSIST WITH DRILLING #30 PILOT HOLES AS AN OPTION. ONLY QTY (2) HOLES PER SADDLE ON FWD-OUTBD AND AFT-INBD LOCATIONS, FINAL SIZE =  $\phi 0.393 - \phi 0.400$ .

RELEASED  
2019 JUN 19  
ECN19-68 NO

APPROVED

|            |  |  |              |
|------------|--|--|--------------|
| C          | REPLACED SKIDTUBES D130-1048-013/-014 WAS -011/-012, DELETED D130-1048-053 MIDTUBE WEARPLATE KITS (MOVED INTO D130-1048-013/-014 ASSEMBLIES), CHANGED DESCRIPTION "HEAVY DUTY LANDING GEAR ASSEMBLY" WAS "LANDING GEAR ASSEMBLY WITH MIDTUBE WEARPLATES" | ZF   | 19.04.05     |
| B          | ADDED MINIMUM INSERTION DEPTH TO NOTE 8 AND DETAIL A, ADDED NOTE 19, ALTERNATE WASHER NAS1149C0732R WAS LN9025-1220L, ADDED D4012-1 CUSHION CALLOUT TO SECTION D-D   | ZF   | 19.02.21     |
| A          | NEW ISSUE  | ZF   | 18.10.24     |
| REV.       | DESCRIPTION  | BY   | DATE         |
| DESIGN     | ZF   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | ZF   |  |              |
| CHECKED    | MW   | DRAWING NO.  | REV. C       |
| MFG. APPR. | JFS  | <b>D130-1048-711</b>   | SHEET 1 OF 2 |
| APPROVED   | NO   | TITLE  | SCALE        |
| DE APPR.   | CP   | <b>LANDING GEAR ASSY (EC130)</b>   | NTS          |
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|------------|----------|--|--------------|
| DESIGN     | ZF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | ZF       |  |              |
| CHECKED    | MW       | DRAWING NO.<br><b>D130-1048-711</b>  | REV. C       |
| MFG. APPR. | JFS      |  | SHEET 2 OF 2 |
| APPROVED   | NO       | TITLE  | SCALE        |
| DE APPR.   | CP       | <b>LANDING GEAR ASSY (EC130)</b>   | NTS          |
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**D130-1048-711 HEAVY DUTY LANDING GEAR ASSY**

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2019 JUN 19

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